












Date: Thursday, 7/13/2006 3:38:09 PM  
User: Kim Johnston

# Process Sheet

|  |   |   |               |
|--|---|---|---------------|
| Customer   | : CU-DAR001 Dart Helicopters Services   | Drawing Name  | : TUBE        |
| Job Number   | : 27900   |   |               |
| Estimate Number  | : 11172   |   |               |
| P.O. Number  | : N/A   | Part Number   | : D22827      |
| This Issue   | : 7/13/2006   | S.O. No.  | : N/A         |
| Prsht Rev.   | : NC  | Drawing Number  | : D2282 REV E |
| First Issue  | : N/A   | Project Number  | : N/A         |
| Previous Run   | : 26817   | Drawing Revision  | : E           |
|  |   | Material  | : N/A         |
|  |   | Due Date  | : 8/15/2006   |
| Written By   | :   | Qty:  | 200           |
| Checked & Approved By  | :   | Um:   | Each          |
| Comment  | : Est Rev:A Removed from 9 Digit 05-12-02 JLM                                       |   |               |
| Additional Product   |   |   |               |
| Job Number:   |   |   |               |
| Seq. #:  | Machine Or Operation:   | Description :   |               |
| 1.0  | M304TR0675W091  | 304 RD Tube .675 x .091W  |               |
|  |    |    |               |
| Comment: Qty.: 0.0699 f(s)/Unit Total : 13.9860 f(s)<br>Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness<br>(M304TR0.675W.091)<br>Batch <u>19524 13.986 F.</u> |   |   |               |
| 2.0  | HARDINGE  | HARDINGE CNC LATHE SMALL  |               |
|  |  |  |               |
| Comment: HARDINGE CNC LATHE SMALL<br><br>1-Turn as per Dwg D2282 and Folio FA190<br><br>2-Deburr   |   |   |               |
| 3.0  | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE  |               |
|  |  |  |               |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE  |   |   |               |
| 4.0  | QC8   | SECOND CHECK  |               |
|  |  |  |               |
| Comment: SECOND CHECK  |   |   |               |
| 5.0  | PACKAGING 1   | PACKAGING RESOURCE #1   |               |
|  |  |  |               |
| Comment: PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: <u>ST 393</u>  |   |   |               |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: 7/01 |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|-----------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE      | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|           |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|           |      |                                  |                             |                                  |                |                           |                        |                          |
|           |      |                                  |                             |                                  |                |                           |                        |                          |
|           |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/09/07

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 7/13/2006 3:38:10 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 27900

Part Number: D22827

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



200

Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/07

Job Completion



u 06-09-07

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

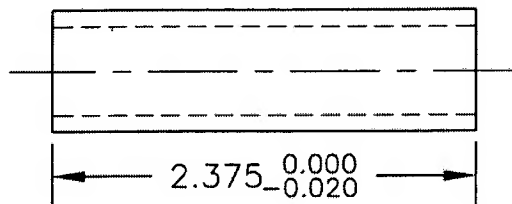
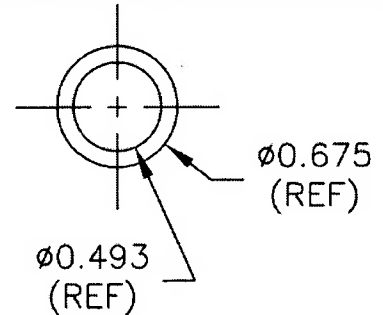
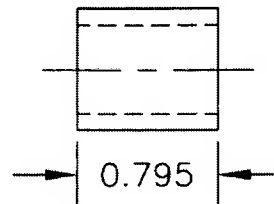


**DART**

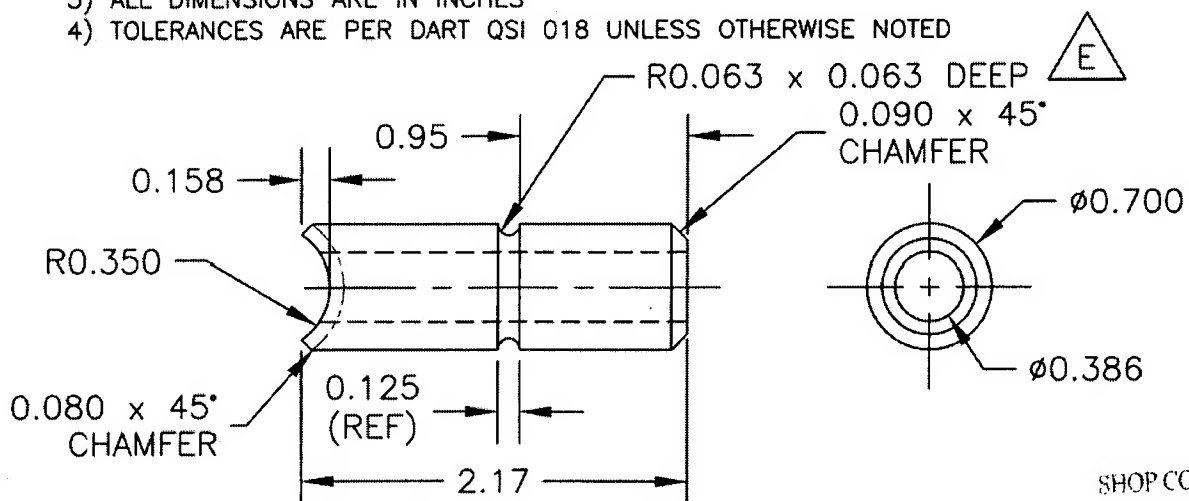
|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282  | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07              |                                | TITLE<br>HANDLE TUBES   | SCALE<br>1:1           |
| A                             | 94.10.14                       | NEW ISSUE   |                        |
| B                             | 95.03.23                       | RE-DESIGN   |                        |
| C                             | 97.10.20                       | CORRECTED NUMBERING SCHEME                                      |                        |
| D                             | 05.03.16                       | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                             | 05.06.07                       | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |

RELEASED  
*[Signature]*

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

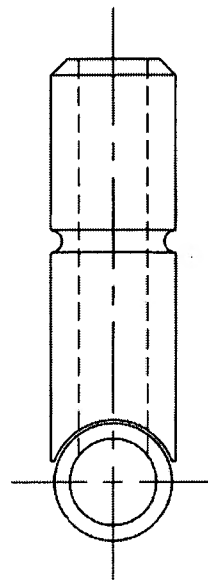
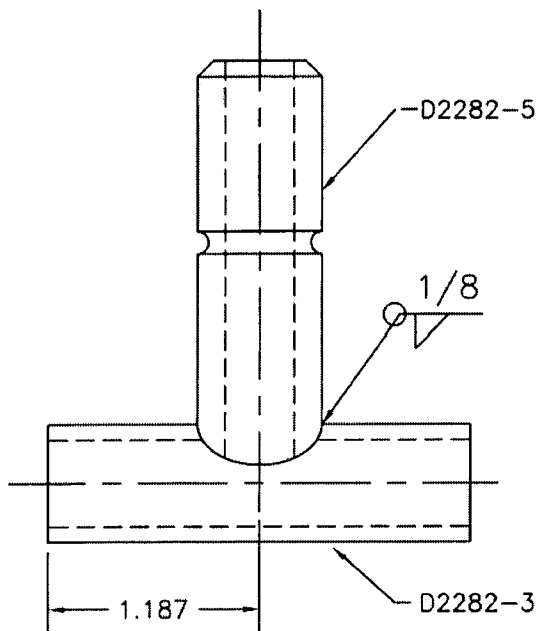
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27900

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

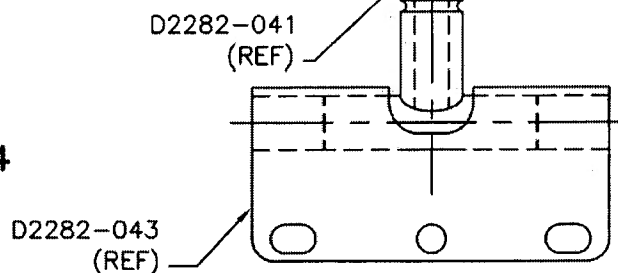


|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW         | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>UP</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>05.06.07     | TITLE<br>HANDLE TUBES          |   | SCALE<br>1:1           |

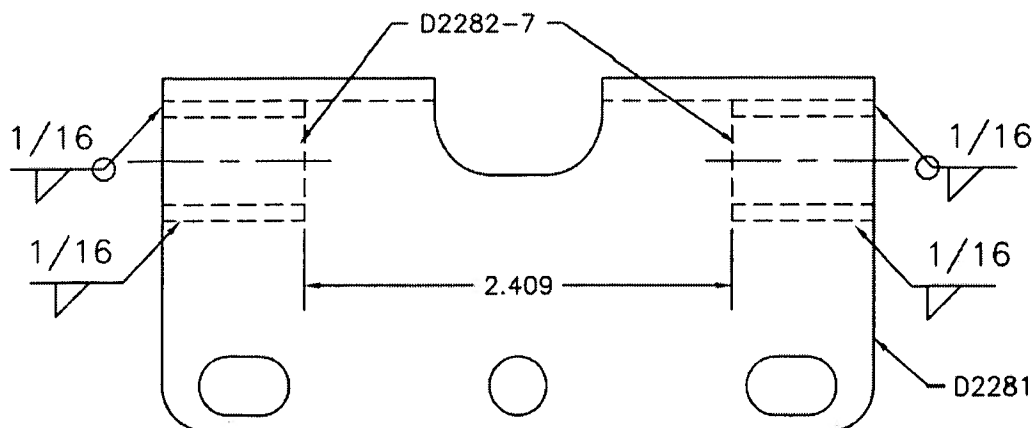


**RELEASED**  
*[Signature]*  
05/09/16

**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27900

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.